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D3171-3

Job Sheet 212281



DAS  
21  
9-89

Part No: D3171-3

Job Qty: 8 pcs

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/18/20

Job Tracking No:

Due Date: 8/31/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 2 IPP REV:A 16-11-10 AS PER DWG REV.B DD VERF:JLM

Ship Via:

## Bill of Materials

## Job Routing

| Op<br>No | Operation           | Qty      | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off    |
|----------|---------------------|----------|------------|-------------|--------------|------------|-----------------------|-----------|-------------|
|          |                     |          |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |             |
| 100      | Waterjet - Flow - 1 | 8<br>pcs |            | 8/29/20     | 0.17         | 1.24       | Waterjet - Flow       |           | on 20/08/24 |
|          |                     |          |            |             |              |            | Waterjet - Omax       |           |             |
| 120      | QC 8                | 8<br>pcs |            | 8/29/20     | 0.00         | 0.00       | QC 8 - 12             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 14             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 17             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 20             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 25             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 3              |           |             |
|          |                     |          |            |             |              |            | QC 8 - 32             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 33             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 35             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 39             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 4              |           |             |
|          |                     |          |            |             |              |            | QC 8 - 44             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 45             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 49             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 58             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 8              |           |             |
|          |                     |          |            |             |              |            | QC 8 - 9              |           |             |
|          |                     |          |            |             |              |            | QC 8 - 68             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 67             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 1 (A)          |           |             |
|          |                     |          |            |             |              |            | QC 8 - 47             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 40             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 52             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 23             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 57             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 76             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 61             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 66             |           |             |
|          |                     |          |            |             |              |            | QC 8 - 73             |           |             |

DAS  
AUG 21 2020  
40  
9-89

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|     |                             |                          |         |           |                             |                     |
|-----|-----------------------------|--------------------------|---------|-----------|-----------------------------|---------------------|
| 130 | Small Fab - Brake NC - B4B  | 8<br>pcs                 | 8/31/20 | 0.25 0.40 | QC 8 - 82                   |                     |
|     |                             |                          |         |           | Small Fab - Brake - 1 - B4B |                     |
|     |                             |                          |         |           | Small Fab - Brake - 2 - B4B |                     |
|     |                             |                          |         |           | Small Fab - Brake - 3 - B4B | AUG 25 2020         |
| 150 | QC 5                        | 8<br>pcs                 | 8/31/20 | 0.00 0.00 | QC 5 - 10                   |                     |
|     |                             |                          |         |           | QC 5 - 12                   |                     |
|     |                             |                          |         |           | QC 5 - 17                   |                     |
|     |                             |                          |         |           | QC 5 - 18                   |                     |
|     |                             |                          |         |           | QC 5 - 19                   |                     |
|     |                             |                          |         |           | QC 5 - 22                   |                     |
|     |                             |                          |         |           | QC 5 - 24                   |                     |
|     |                             |                          |         |           | QC 5 - 3                    |                     |
|     |                             |                          |         |           | QC 5 - 43                   |                     |
|     |                             |                          |         |           | QC 5 - 49                   |                     |
|     |                             |                          |         |           | QC 5 - 51                   |                     |
|     |                             |                          |         |           | QC 5 - 58                   |                     |
|     |                             |                          |         |           | QC 5 - 68                   |                     |
|     |                             |                          |         |           | QC 5 - 9                    |                     |
|     |                             |                          |         |           | QC 5 - 50                   |                     |
|     |                             |                          |         |           | QC 5 - 30                   |                     |
|     |                             |                          |         |           | QC 5 - 40                   | AUG 25 2020 40      |
|     |                             |                          |         |           | QC 5 - 61                   | 9-89                |
|     |                             |                          |         |           | QC 5 - 81                   |                     |
|     |                             |                          |         |           | QC 5 - 82                   |                     |
| 160 | Packaging 3-1 - Stock - B4B | 8<br>pcs<br>9 pcs<br>mko | 8/31/20 | 0.00 0.00 | Packaging 3 - 1 - B4B       |                     |
|     |                             |                          |         |           | Packaging 3 - 2 - B4B       |                     |
|     |                             |                          |         |           | Packaging 3 - 3 - B4B       |                     |
|     |                             |                          |         |           | Packaging 3 - 4 - B4B       |                     |
|     |                             |                          |         |           | Packaging 3 - 5 - B4B       | DAS                 |
|     |                             |                          |         |           | Packaging 3 - 6 - B4B       | 28                  |
|     |                             |                          |         |           | Packaging 3 - 7 - B4B       | 9-89                |
|     |                             |                          |         |           | Packaging 3 - 8 - B4B       |                     |
|     |                             |                          |         |           | Packaging 3 - 9 - B4B       | AUG 25 2020         |
|     |                             |                          |         |           | Packaging 3 - 10 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 11 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 12 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 13 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 14 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 15 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 16 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 17 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 18 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 19 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 20 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 21 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 22 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 23 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 24 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 25 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 26 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 27 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 28 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 29 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 30 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 31 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 32 - B4B      |                     |
|     |                             |                          |         |           | Packaging 3 - 33 - B4B      |                     |
|     |                             |                          |         |           | Plex 8/18/20 3:21 PM        | Dart.lajeunesse.mar |



|                |          |         |           |                        |      |
|----------------|----------|---------|-----------|------------------------|------|
| 170 QC 21 - SA | 8<br>pcs | 8/31/20 | 0.00 0.00 | Packaging 3 - 34 - B4B |      |
|                |          |         |           | Packaging 3 - 35 - B4B |      |
|                |          |         |           | Packaging 3 - 36 - B4B |      |
|                |          |         |           | Packaging 3 - 37 - B4B |      |
|                |          |         |           | QC 21 - SA - 21        | DAS  |
|                |          |         |           | QC 21 - SA - 70        | 21   |
|                |          |         |           | QC 21 - SA - 9         | 3-88 |
|                |          |         |           | QC 21 - SA - 77        |      |

AUG 25 2020

Part Op 100 - 1-Cut as per Dwg D3171  
 Descriptions: 120 - QC8- Inspect parts - second check  
 130 - Form as per dwg - Bend as per Dwg D3171  
 150 - QC5- Inspect part completeness to step on W/O  
 160 - Identify as per dwg & Stock Location:  
 170 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item | Component Name     | Quantity            | Operation               | Container |
|-------------|--------------------|---------------------|-------------------------|-----------|
| M304S24GA   | 304/316 .025 Sheet | .1688 sf (.0211 ea) | 100-Waterjet - Flow - 1 | 5175007   |

## Job Allocations

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M304S24GA      | 0        | 38        | 0         |

## Part Specifications

| Spec No | Description | Target/Tolerance               | Limits         | Type     | Special Comments |
|---------|-------------|--------------------------------|----------------|----------|------------------|
| 1       | Angle       | 0.257Inches + 0.006<br>- 0.001 | 0.263<br>0.256 | Diameter | .256             |
| 2       | Angle       | 0.500Inches + 0.006<br>- 0.001 | 0.506<br>0.499 | Diameter | .501             |
| 3       | Angle       | 0.400Inches ± 0.030            | 0.430<br>0.370 |          | .399             |
| 4       | Angle       | 0.590Inches ± 0.010            | 0.600<br>0.580 |          | .591             |
| 5       | Angle       | 1.180Inches ± 0.030            | 1.210<br>1.150 |          | 1.183            |
| 6       | Angle       | 2.580Inches ± 0.030            | 2.610<br>2.550 |          | 2.579            |
| 7       | Angle       | 0.025Inches ± 0.010            | 0.035<br>0.015 |          | .025             |
| 8       | Angle       | 1.587Inches ± 0.010            | 1.597<br>1.577 |          | 1.590            |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



**Container No: S295675**



**Part: D31.1-3**

**Job No: 212281**

**Serial No/Batch: S295675**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

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Date: 09/24/20